

Work Order ID 66947

Thursday, March 03, 2011 8:46:15 AM



Page 1

Item ID: D3283-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 3/3/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: H Date: 11-03-3 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3283	Rev E

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3283 ☐ Dwg Rev: E ☐ Prog Rev: E ☐ 2-
Deburr if necessary

6061 . 063

B11-3-8



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-3-9

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/09

counted
x27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	*****ensure rivet fits in #30 (0.128") holes as per dwg *****								
150 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

m/d 29.4 11/03/11

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Setup Start



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Stop



Item Name: Doubler

Start Date: 3/3/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

29 d 21 4/03/11

170

Identify as per dwg & Stock Location: 4/5

0.00



Packaging

Memo

0.00

Packaging

count dec

11/3/11 29 SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/11 29 SP

MS
11-03-11

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Picklist Print

Thursday, March 03, 2011 8:46:24 AM

Page 1

Work Order ID: 66947

Parent Item: D3283-1

Parent Item Name: Doubler



Start Date: 3/3/2011

Required Date: 3/11/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP ☐ A ☐ 04.09.28 ☐ New issue ☐ KJ/JLM ☐
 IPP Rev:B Now on Waterjet 07-05-28 JLM
 IPP Rev:C As per Rev E 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

100

sf

139.5000

0.2361

4.970526

7.



6061-T6 .063 Sheet



B11-3-8

Location

Loc Qty

Loc Code

MAT

105.6

116308

28.6

116623

77

MAT21

33.9

113608

33.9

116623

(29)

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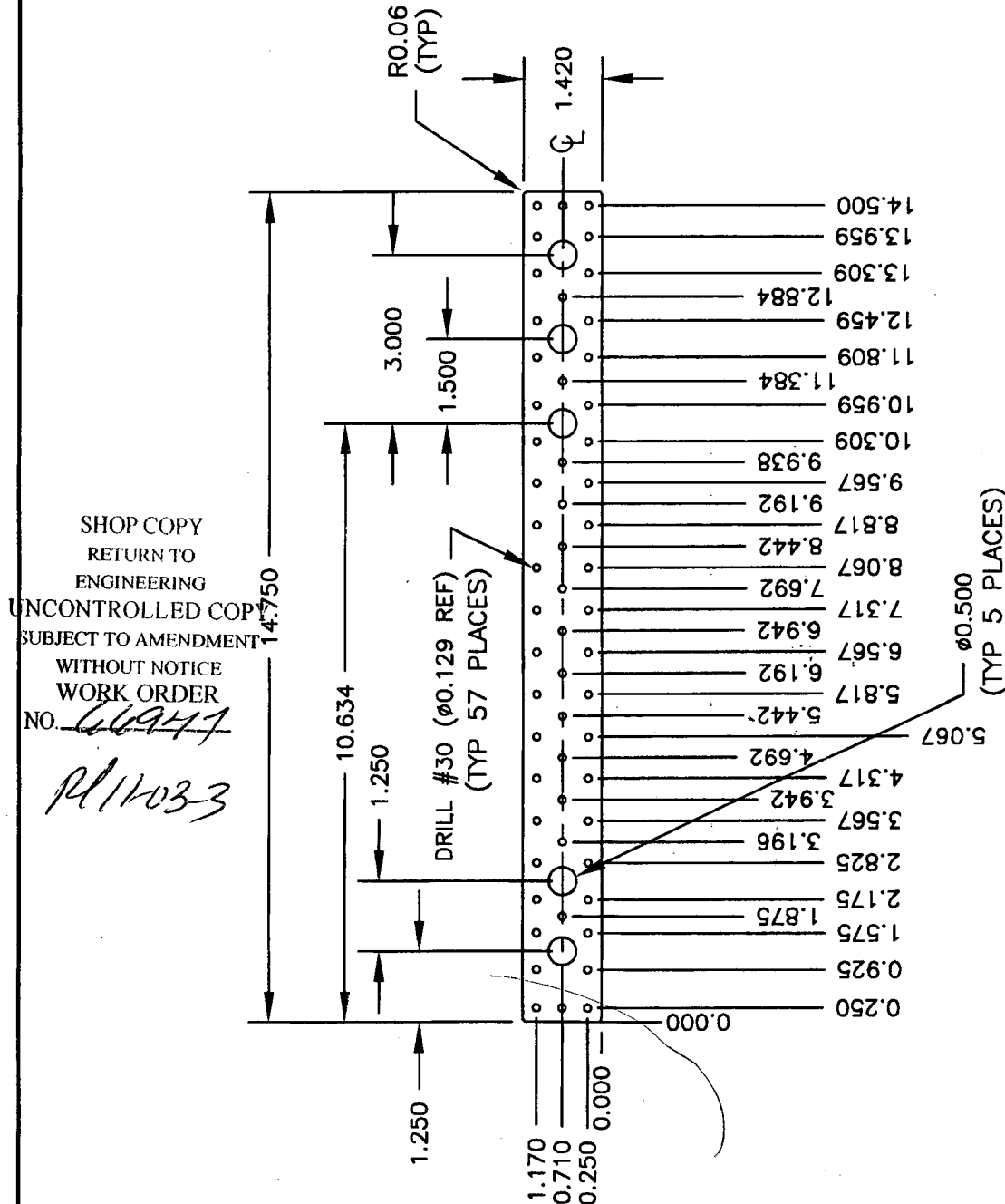
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NOTE: Date & initial all entries

DART

RELEASED
07-08-2004
PER ECN 959

DESIGN <i>GP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>B</i>	APPROVED <i>HH</i>	DRAWING NO. D3283	REV. E SHEET 1 OF 2
DATE 07.06.01		TITLE DOUBLER	SCALE 1:3
A	04.05.06	NEW ISSUE	
B	04.08.09	10.882 WAS 11.502	
C	05.03.16	CHANGE HOLE PATTERN FOR -1	
D	05.08.09	REDESIGN	
E	07.06.01	MISSING HOLE ADDED @ (7.692, 0.710)	



D3283-1 DOUBLER
1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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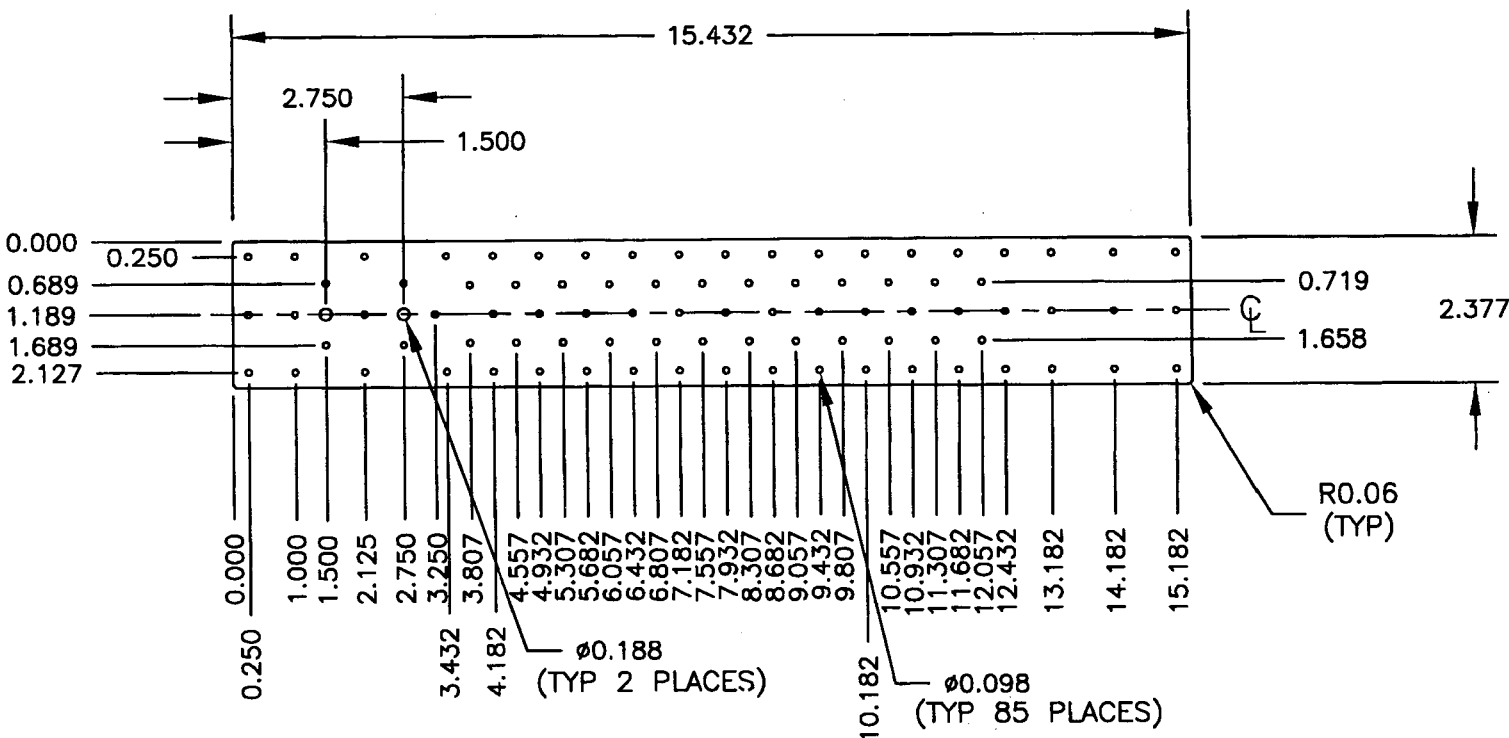
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	DRAWING NO.	PORT HADLOCK, WA
DATE		TITLE	REV. E
07.06.01		DOUBLER	SHEET 2 OF 2
			SCALE
			1:3

RELEASED
07-08-2004
PER ECN 969

u/o 66947



D3283-3 DOUBLER

- 1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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